

Work Order ID 120675

June-10-14 10:40:01 AM

AS AD
120675

Page 1

Item ID: D3564-11

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Stainless Steel Wearplate Aft

Stop

NS2

Start Date: 6/10/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/10/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 14-06-10

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
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D3564	Rev D	
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100		0.00							
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100	FLOW WATER JET								
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Waterjet	Memo	0.00							
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FLOW CNC Waterjet	1-Cut as per Dwg D3564 ****(D3564-1F)****Dwg Rev: <u>D</u> Prog Rev: <u>D</u> 2-Deburr if necessary								
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13 0 9-89 14-06-18

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--

110	Memo	0.00							
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QC									
----	--	--	--	--	--	--	--	--	--

Quality Control									
-----------------	--	--	--	--	--	--	--	--	--

DAS

23

9-89

14-06-18

120	QC8- Inspect parts - second check	0.00							
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QC	Memo	0.00							
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Quality Control									
-----------------	--	--	--	--	--	--	--	--	--

SH
14/6/13

13

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Item ID: D3564-11

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N900040100

Setup Start

NS1

Revision ID:

Item Name: Stainless Steel Wearplate Aft

Stop

NS2

Start Date: 6/10/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/10/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

NC BRAKE

0.00

DAS

13

14/06/25

Brake NC

Memo

0.00

30

Brake NC

Deburr if necessaryForm on Brake as per Dwg D3564 using Jigs DT8179

9-89

140

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

SPH
14/06/25

13

150

150

Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

Qty Description Batch A/R 2059B Hardcoat
M1291694 Weld hardcoat as per Dwg D3437

13 20 14.06.15

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Item ID: D3564-11

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Stainless Steel Wearplate Aft

Stop

NS2

Start Date: 6/10/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/10/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC10- Inspect visual per QSI004- ground welds 0.00 (13) 1407-15 DAS
160 QC 9
Quality Control Memo 0.00 9-00

170 QC5- Inspect part completeness to step on W/O 0.00 (13) 14-07-15 DAS
170 QC 9
Quality Control Memo 0.00 9-00

180 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00 (13) 14-07-15 DAS
180 Powdercoat 125028
Powder Coating Memo 0.00 9-00
START TIME: 3:10 OVEN TEMPERATURE:
FINISH TIME: 4:10

Work Order ID 120675

June 10-14 10:40:01 AM

120675

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Item ID: D3564-11

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Stainless Steel Wearplate Aft

Stop

NS2

Start Date: 6/10/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/10/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

190

QC

Quality Control

13 6/14-5-16 CK

Das 9-89

200

Identify as per dwg & Stock Location: FP-002 0.00

200

Packaging

Packaging

0.00

x13 ✓ All work done

210

QC21- Final Inspection - Work Order Release 0.00

210

QC

Quality Control

0.00

MJ 14-07-16

MF 7-16

Picklist Print

June-10-14 10:40:06 AM

Page 1

Work Order ID: 120675

120675
D3564-11

Parent Item: D3564-11

Parent Item Name: Stainless Steel Wearplate Aft

Start Date: 6/10/14

Required Date: 6/10/14

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
 IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ
 Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	144.8670	1.41	18			DAS 23 9-89 14-06-12

M304S16GA

304/316 Sheet .063

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	144.867	
M127821	75.567	
M128423	1.2	
M129192	68.1	129192

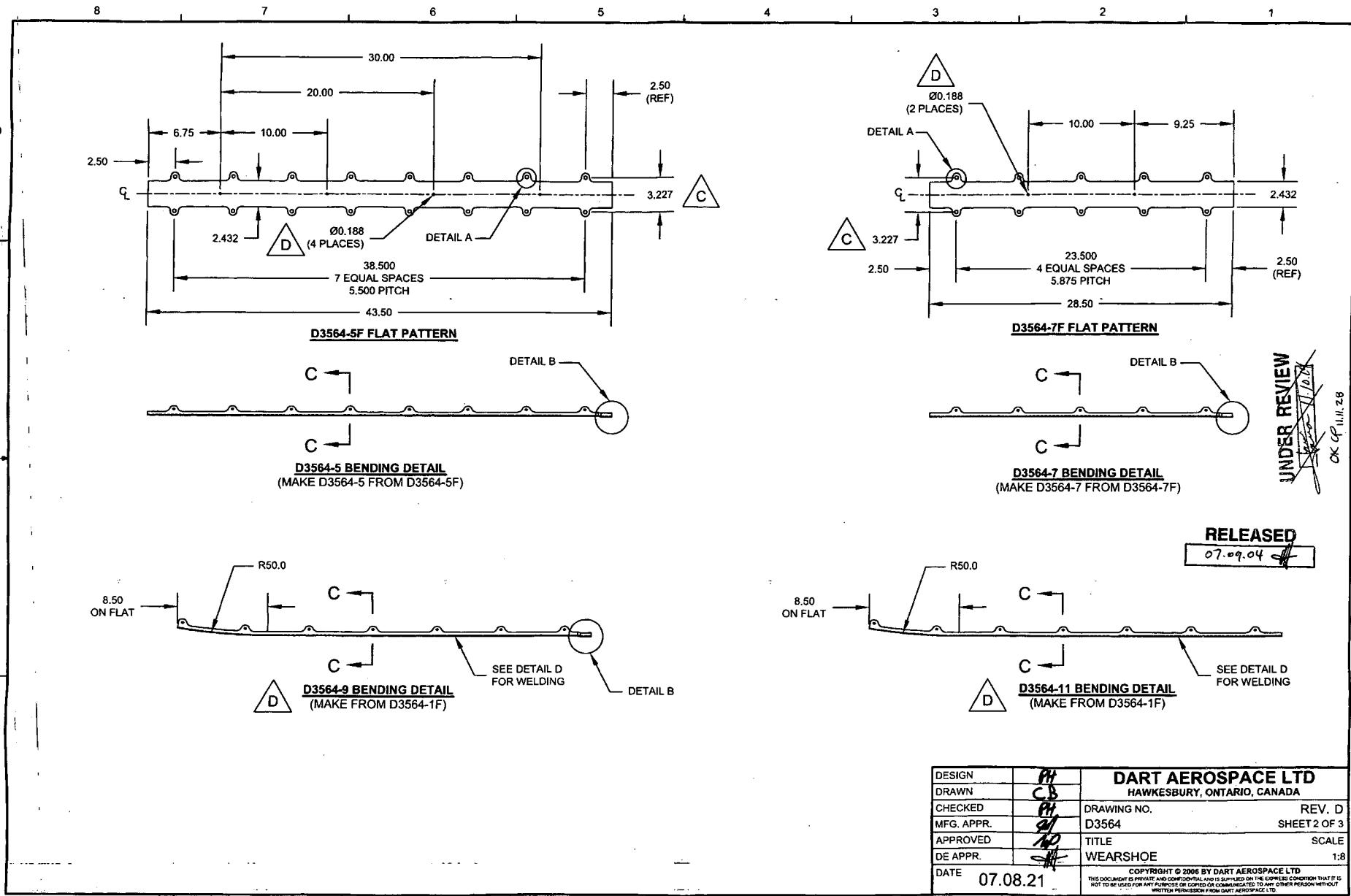
DART AEROSPACE LTD	Work Order:	120675
Description: Wearshoe -	Part Number:	D3564-11
Inspection Dwg: D3564	Rev: D	Page 1 of 1

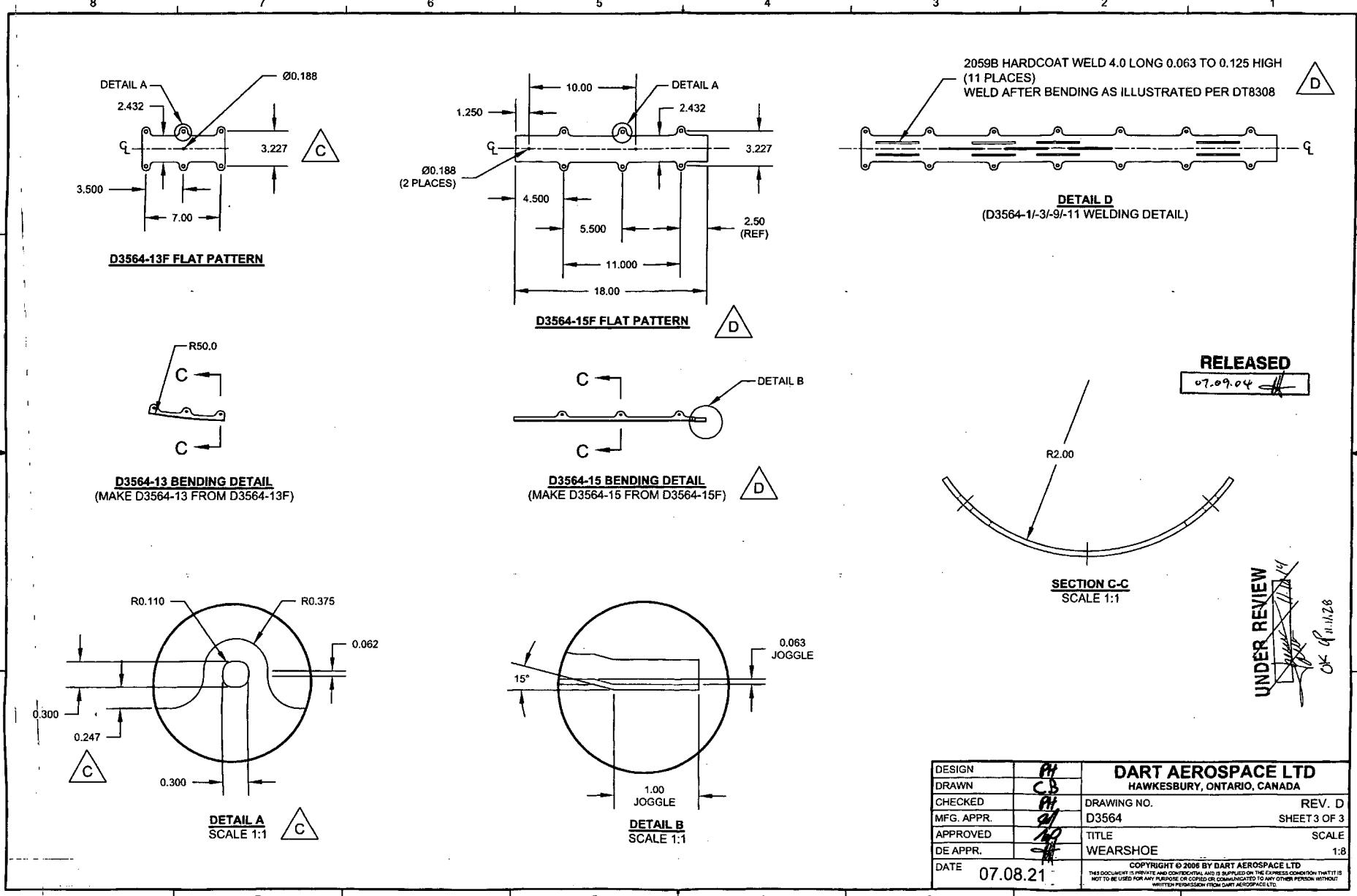
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

DAS			
Measured by:	23 9.89	Audited by:	SMP
Date:	14-06-12	Date:	14/6/13

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	07.11.23	Dwg Rev updated	KJ/EC/DD	





DESIGN	PH	DART AEROSPACE LTD
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	REV. D
MFG. APPR.	SI	DRAWING NO. D3564
APPROVED	NO	REV. D
DE APPR.	NO	TITLE WEARSHOE
DATE	07.08.21	SCALE 1:8

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